

Date: Tuesday, 11/27/2007 7:49:06 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206 L WEB
Job Number : 35994	
Estimate Number : 10722	
P.O. Number : N/A	Part Number : D26547
This Issue : 11/27/2007 S.O. No. : N/A	Drawing Number : D2654 REV E1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : E1
Previous Run : 34594	Material : N/A
Written By : <u>JA 07.11.27</u>	Due Date : 12/6/2007
Checked & Approved By : <u>JA 07.11.27</u>	Qty: 10 Um: Each
Comment : Est Rev: 99.02.04 Fixed typo, Changed procedure DM Est Rev: 06.04.05 Added level 21 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26007140	EXT. "I BEAM" THICK
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Pick:

Qty	Part Number	Description	Batch
1	D2600-7- 140	Web	B21966 (10) H 7-11-29

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-7 to length as per Dwg D2654

2-Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

) H 7-11-29
 (10)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SL 07/12/03

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SL 7-12-03

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 1 Date: 07/12/04

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/27/2007 7:49:06 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L WEB

Job Number: 35994

Part Number: D26547

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 7-12-04

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

SL 7-12-04

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

10/12/04

Job Completion



LG 7-12-04

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

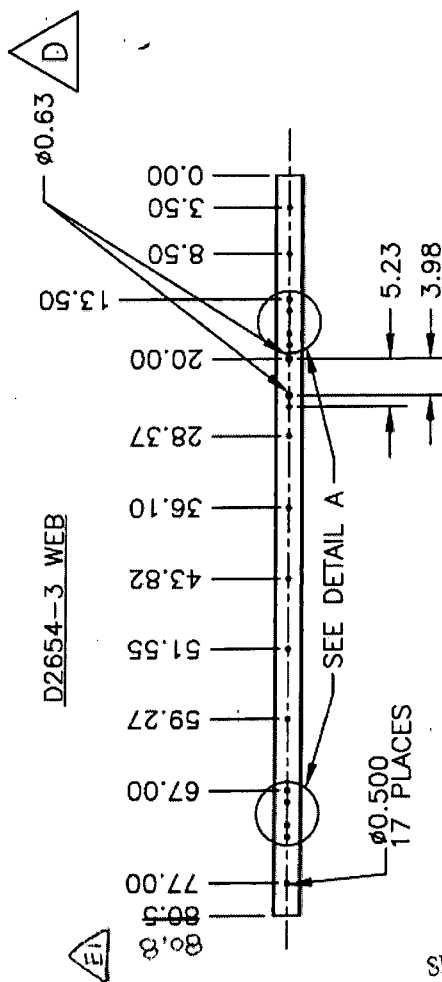
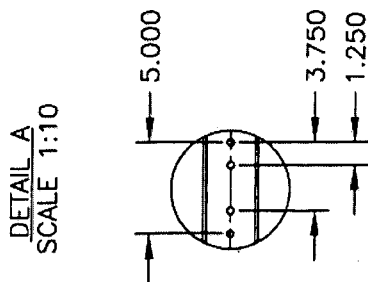
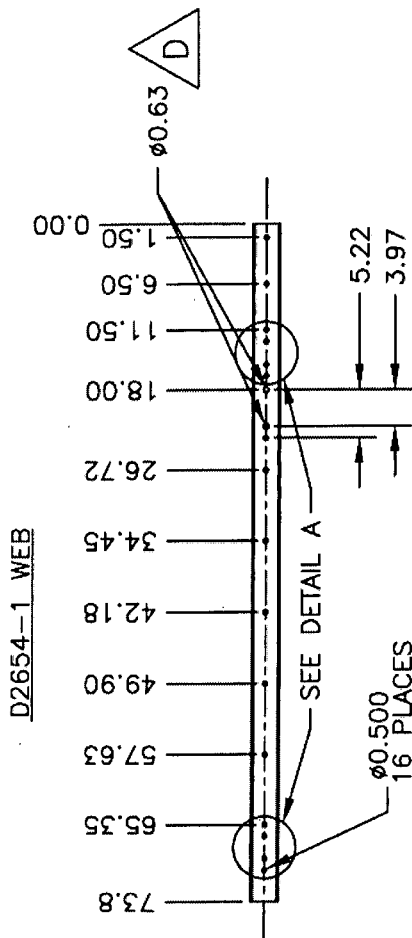
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	#	APPROVED	#	DRAWING NO.	REV. E
				D2654	SHEET 1 OF 2
DATE	04.05.26			TITLE	SCALE
				WEB	1:20
A	97.03.25	NEW ISSUE			
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438			
C	97.10.29	CHANGED HOLE PATTERN			
D	98.01.15	GHW HOLES CHANGED TO $\phi 0.63$			
E	04.05.26	CHANGE LENGTHS, REFORMAT			
E1	04.08.04	PER TOOLING; 80.8 WAS 80.5			

RELEASED
04.06.22

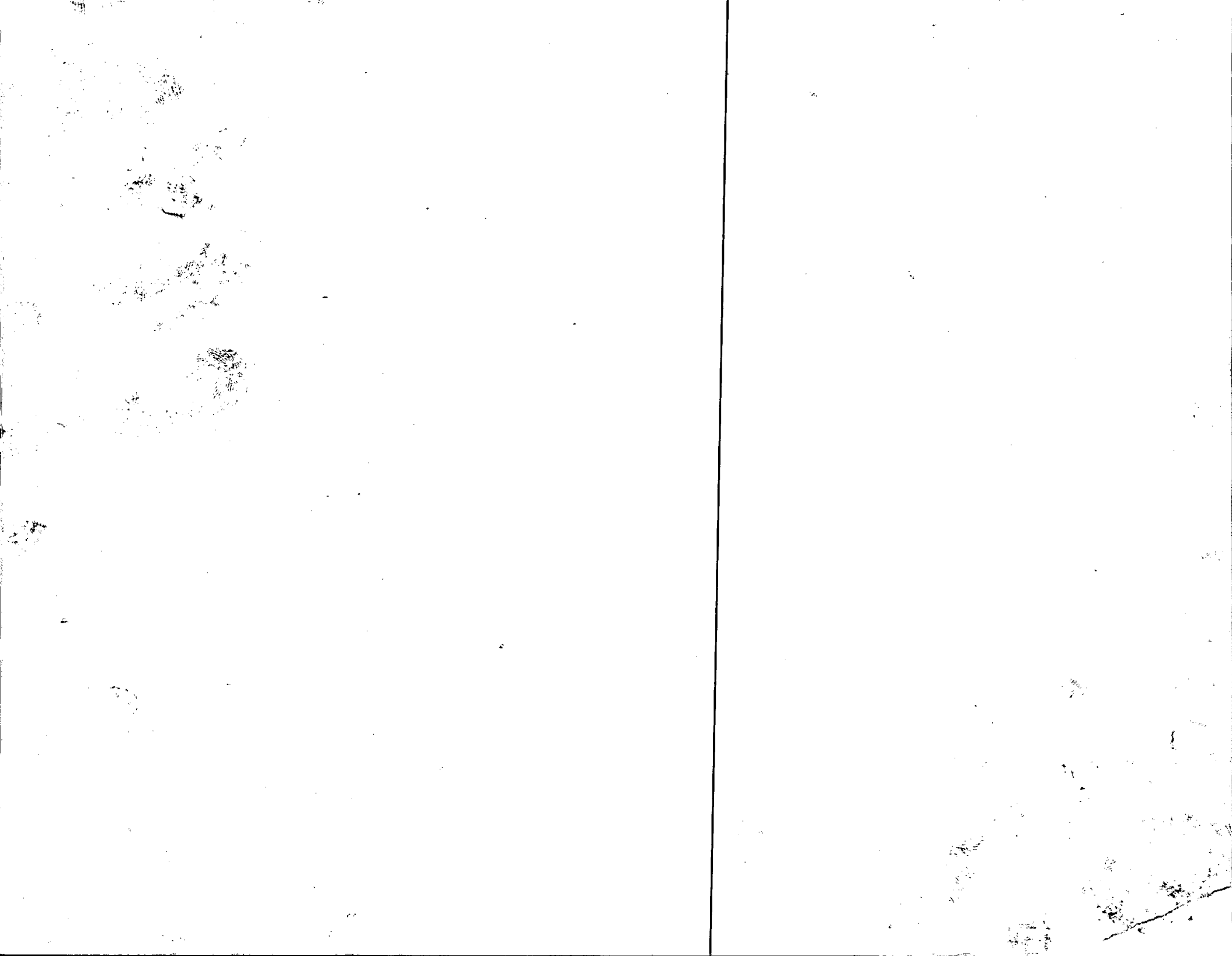


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NO. 35994

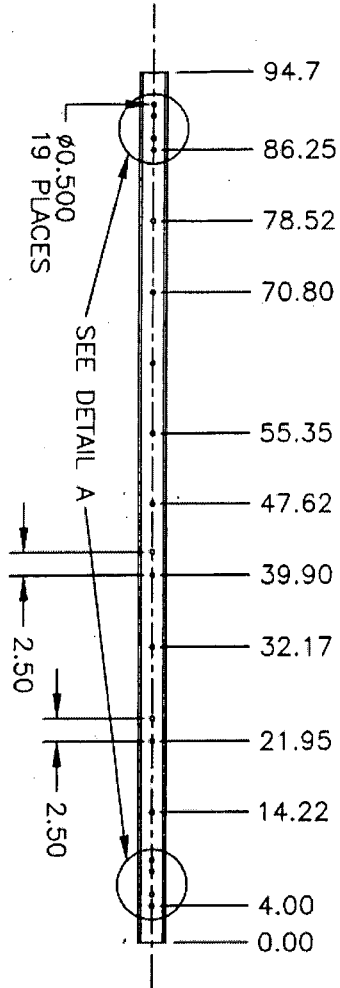
MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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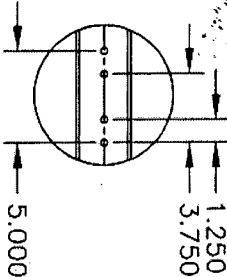
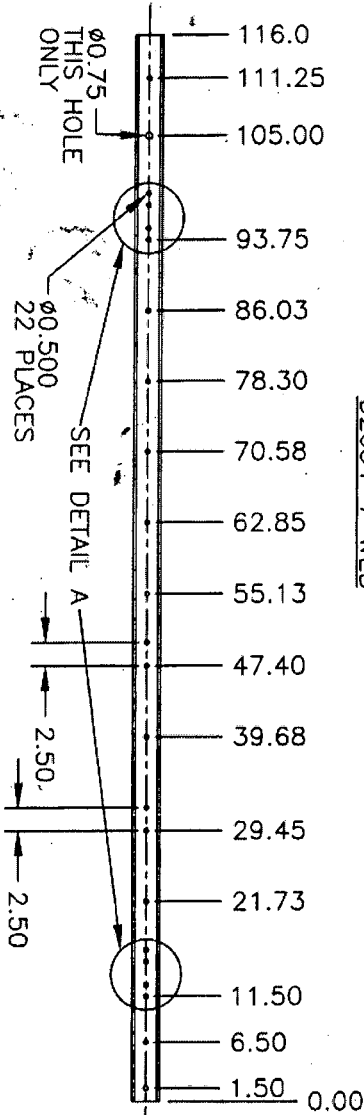


D2654-5 WEB



DETAIL A
 SCALE 1:10

D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 TOLERANCES ARE PER DART QSI 018. UNLESS OTHERWISE NOTED

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DESIGN	DRAWN BY	APPROVED	CHECKED	DATE	04.05.26
DART AEROSPACE USA, INC.	PORT HADLOCK, WA	D2654	WEB	TITLE	1:20
REV. E	SHEET 2 OF 2	SCALE	DATE	04.05.26	1:20



RELEASED
 04.06.22